

Work Order ID 57724

April 14, 2010 10:32:00 AM



Page 1

Item ID: D2528-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Backer Plate

Start Date: 14/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-11-14* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2528

Rev C1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

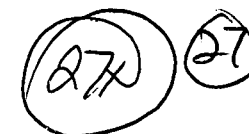
FLOW CNC Waterjet

1-Cut as per Dwg D2528 ☐ Dwg Rev: *C1* ☐ Prog Rev: *C1* ☐ 2-
Deburr if necessary

5052 . 063

=> Deburr m-f 10/04/16

B10-4-15



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-4-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.06.16



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57724

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Item ID: D2528-1	Accept		Setup	Start	
Revision ID:				Stop	
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Start Date: 14/04/2010	Start Qty: 20.00		Cust Item ID:		
Required Date: 22/04/2010	Req'd Qty: 20.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	WJ	10/04/20		27	Ø		
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M1114207 Memo START TIME: 8:15am OVEN TEMPERATURE: 8:45am FINISH TIME: 320°F	0.00 0.00	=7 JH	10/04/21		27	Ø		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

(27) BK 10-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 57724

April 14, 2010 10:32:00 AM



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Start Date:	14/04/2010	Start Qty: 20.00		Cust Item ID:		
Required Date:	22/04/2010	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>ST 17</i>	0.00							
	Packaging								
	Packaging								
				<i>m-h</i>	<i>10/04/26</i>	<i>(27X)</i>			
170	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								

10/04/27
MF
10-4-26

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:32:04 AM

Page 1

Work Order ID: 57724

Parent Item: D2528-1

Parent Item Name: Backer Plate



Comments: IPP: ☐C☐00.06.26☐Removed P/O for powder coat☐EC☐
IPP Rev:D 08-07-23 now made on water jet DD verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	224.0000	0.6379	.86		
<div>   </div>												
5052-H32 .063 Sheet												

B10-4-15

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	192	
114322	192	
Main Warehouse		
MAT22	32	
112442	32	

112442

(27)

W/O:		WORK ORDER CHANGES					
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DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

RELEASED
98.12.11 *KE*

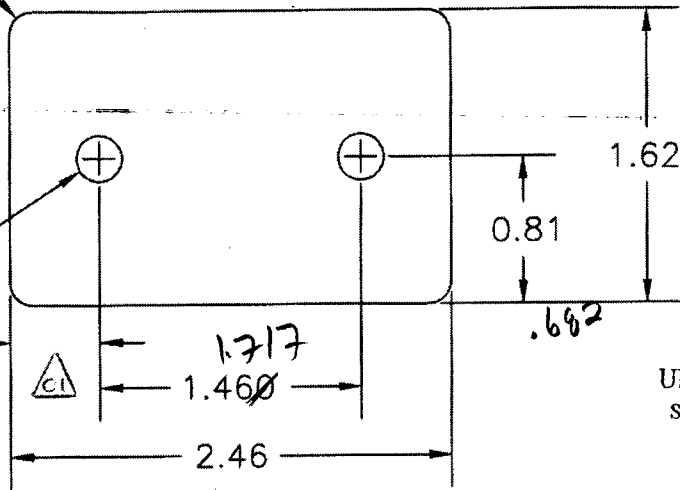
R0.13 (TYP)

UNDER REVIEW
~~108-2163157~~

01L# 03.12.03

$\phi 0.257$ (TYP)
.128

0.50
.371

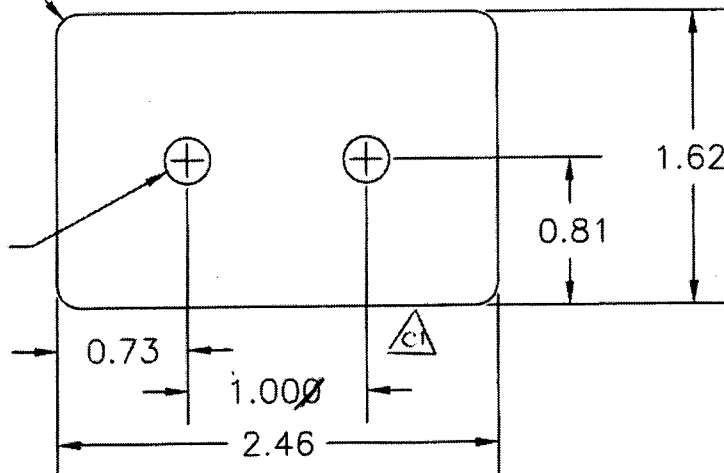


D2528-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57227
BS10-4-14

R0.13 (TYP)

$\phi 0.257$ (TYP)



D2528-3

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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